

Work Order ID 139928

Monday, December 14, 2015 1:51:14 PM

139928

PRELIMINARY ISSUE

Page 1

Item ID: D5336-044 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: PRELIM Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 12/14/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/14/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLC Date: DEC 14 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5336	A3 <u>Rev A</u> <u>DAS 9 9-89</u>								
100	Weld per dwg A/R S.S. rod Batch: <u>4131417</u>	0.00							
100	Large Fab								
Large Fab	Memo	0.03							
Large Fab	1- Assemble ribs , weld as per dwg D5336 using DT10196								
	2- Weld hinge (2) and locking brackets as per dwg D5336 ***inspect before welding mesh***								
	3- Cut mesh as per dwg D5334-3								
	4- Tack weld mesh on basket as per dwg D5336 ***Make sure to place mesh correctly on lid, check with label plate before tacking mesh***								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

1x DAS 43 9-89 JAN 05 2016

① 16-04-29 ②

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	*** Mask sides of hinge prior to powdercoat***								
	Start Time: 2:30								
	Oven Temperature: 320°								
	Finish Time: 3:00								
140	Wing Walk as per dwg QSI005 4.4 Batch Acc 1311	0.00							
140									
HandFinish	Memo	0.01							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg								

POSITIVE RECALL
DEC 14 2015
EFFECTIVE AUTH MJS
RELEASED PD DATE 16-04-21

RD15-1016-01

16-04-25 PD

16-04-21 333

16-04-27

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 139928

139928

Page 3

Monday, December 14, 2015 1:51:14 PM

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 Start Date: 12/14/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/14/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>wlb</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

20160429
SIA

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 139928

139928

Parent Item: D5336-044

D5336-044

Parent Item Name: Basket Lid Assembly

Start Date: 12/14/2015

Required Date: 12/14/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4016-3 *D4016-3* Hinge Half, Lid		Manufactured	No				Each	4.0000		2		DAS 43 9-89	JAN 05 2016
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				4					
					138084			4					
D5333-1 *D5333-1* Locking Bracket		Manufactured	No				Each	0.0000		1		DAS 43 9-89	JAN 05 2016
M304EX0.75-16F *M304EX0 75-16F* Expanded Metal Flat SS		Purchased	No				sf	410.9000		5.052632		DAS 43 9-89	JAN 05 2016
				<u>Location</u>				<u>Loc Qty</u>					
				WA004				410.9					
					M133198			0.4					
					M133466			43.5					
					<u>M133763</u>			367					
D5332-043 *D5332-043* Rib Assembly		Manufactured	No				Each	0.0000		1		DAS 43 9-89	JAN 05 2016
D5332-7 *D5332-7* Rib		Manufactured	No				Each	0.0000		1		DAS 43 9-89	JAN 05 2016
D5332-9 *D5332-9* Rib		Manufactured	No				Each	0.0000		1		DAS 43 9-89	JAN 05 2016

PRELIMINARY ISSUE

** B139807 → 2x

** B138108 → 1x

** M133868 → 6x

** B139935 → 1x

** B139936 → 1x

** B139937 → 1x

DQA: _____ Date: _____

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Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
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OTHER : ☐					

Picklist Print

Monday, December 14, 2015 1:51:17 PM

Page 2

Work Order ID: 139928

139928

Parent Item: D5336-044

D5336-044

Parent Item Name: Basket Lid Assembly

Start Date: 12/14/2015

Required Date: 12/14/2015

Start Qty: 1.00

Required Qty: 1.00

D5332-11 Manufactured No

Each 0.0000

D5332-11 / ✓

Rib

1
**B139938 → 1x DAS 43 JAN 05 2016

D5332-15 Manufactured No

Each 0.0000

D5332-15 / ✓

Rib

1
**B139939 → 1x DAS 43 JAN 05 2016

D5332-17 Manufactured No

Each 0.0000

D5332-17 / ✓

Rib

2
**B139940 → 2x DAS 43 JAN 05 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

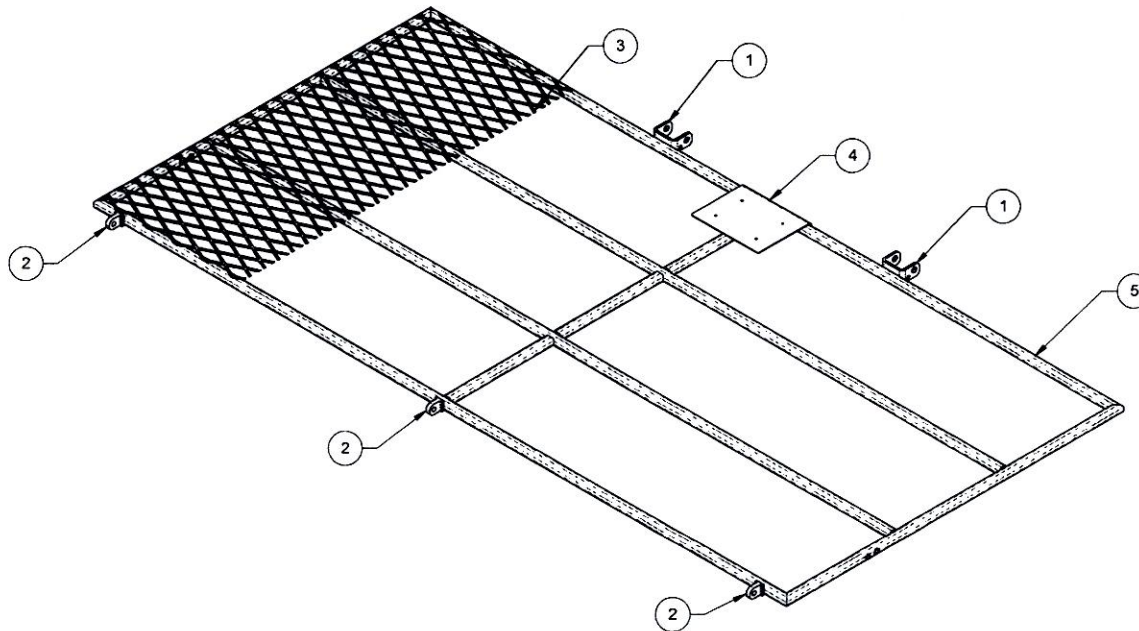
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

PRELIMINARY ISSUE

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5336-041	BASKET LID ASSY
1	2	D2581	MOUNTING BRACKET
2	3	D4016-3	HINGE HALF, LID
3	1	D5334-1	LID MESH
4	1	D5335-1	DATA PLATE
5	1	D5336-101	TUBULAR ASSEMBLY, LID



D5336-041 BASKET LID ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 9.68 lbs
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 139928 MLJ

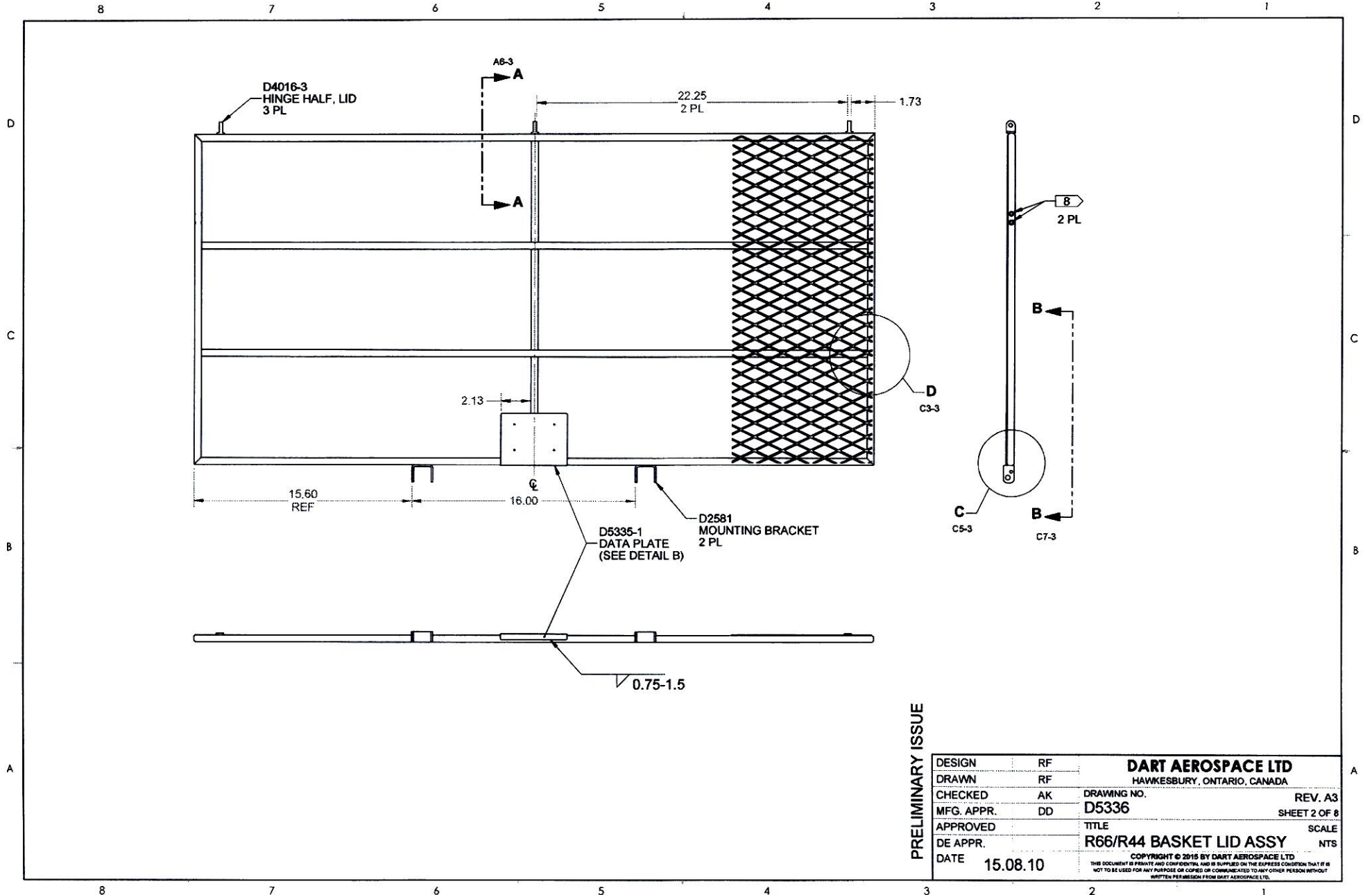
15-12-14

PRELIMINARY ISSUE

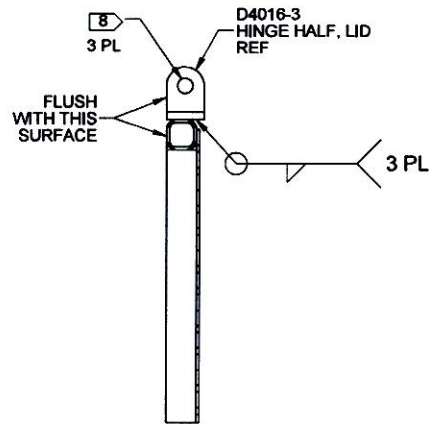
PRELIMINARY ISSUE

A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A3
MFG. APPR.	DD	D5336	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		R66/R44 BASKET LID ASSY	NTS
DATE	15.08.10	COPYRIGHT © 2015 BY DART AEROSPACE LTD	
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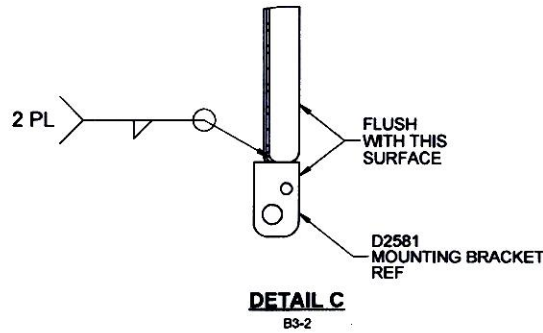
PRELIMINARY ISSUE



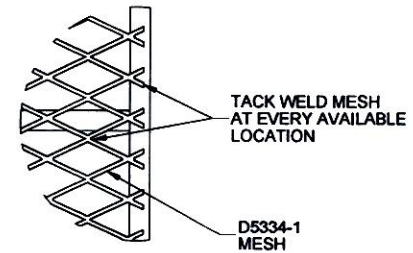
PRELIMINARY ISSUE



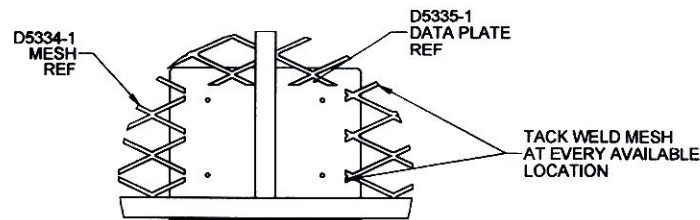
SECTION A-A
D6-2



DETAIL C
B3-2



DETAIL D
C3-2



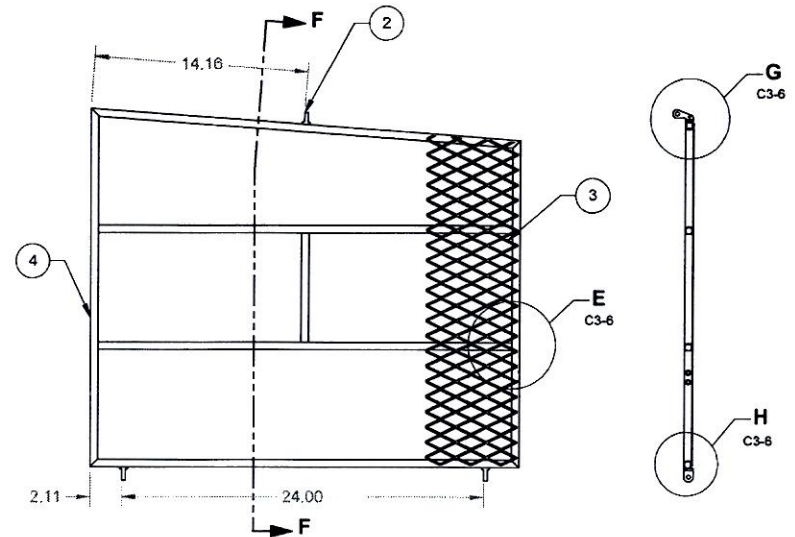
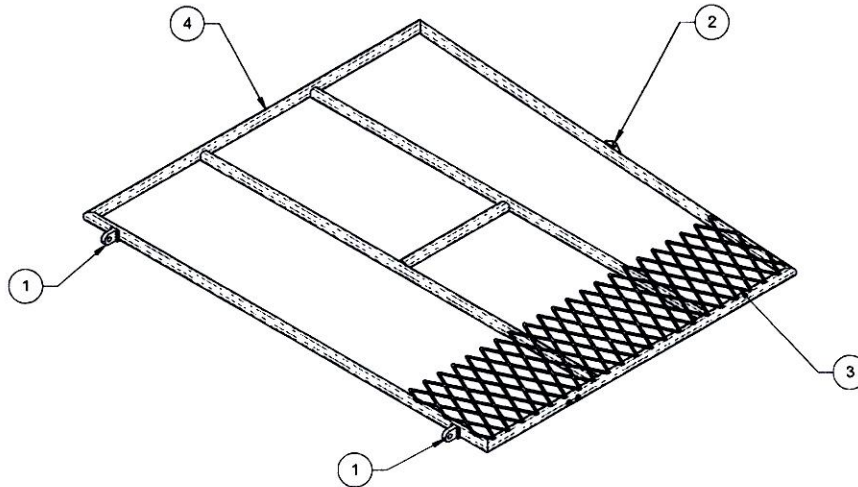
DETAIL B
B2-2

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A3
MFG. APPR.	DD	D5336	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		R66/R44 BASKET LID ASSY	NTS
DATE	15.08.10	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

PRELIMINARY ISSUE

ITEM	QTY -043	P/N	DESCRIPTION
	X	D5336-043	BASKET LID ASSY
1	2	D4016-3	HINGE HALF, LID
2	1	D5333-1	LOCKING BRACKET
3	1	D5334-3	LID MESH
4	1	D5336-103	TUBULAR ASSEMBLY, LID



SECTION F-F

D5336-043 BASKET LID ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

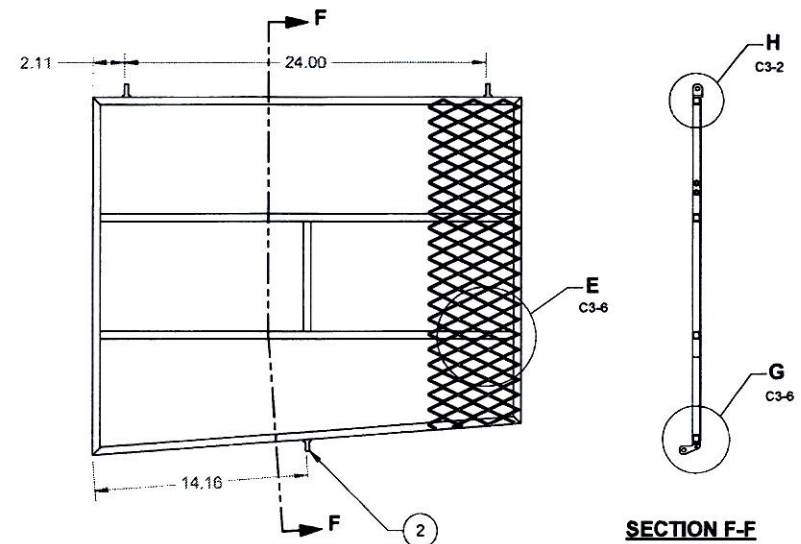
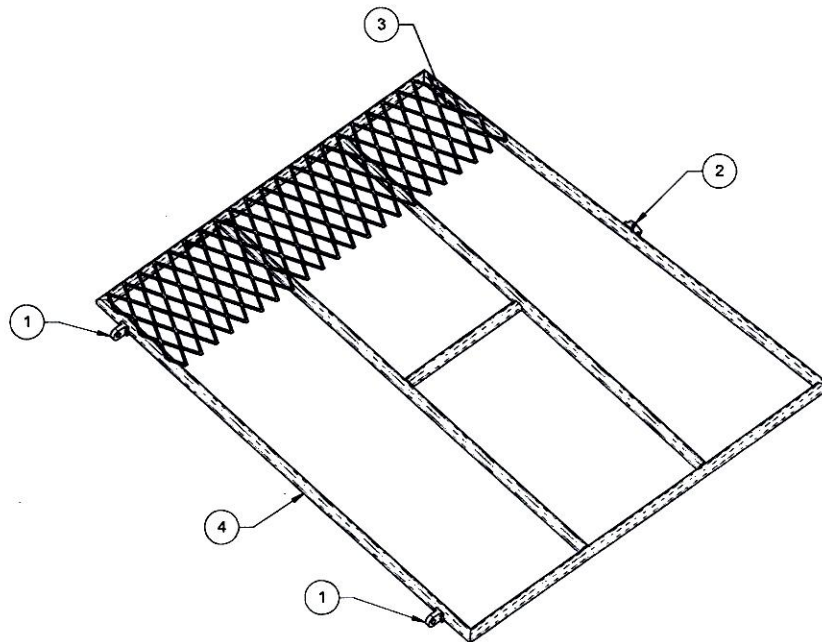
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEXT (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 5.63 lbs
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A3
MFG. APPR.	DD	D5336	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		R66/R44 BASKET LID ASSY	NTS
DATE	15.08.10	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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ITEM	QTY -044	P/N	DESCRIPTION
	X	D5336-044	BASKET LID ASSY
1	2	D4016-3	HINGE HALF, LID
2	1	D5333-1	LOCKING BRACKET
3	1	D5334-3	LID MESH
4	1	D5336-103	TUBULAR ASSEMBLY, LID



D5336-044 BASKET LID ASSY. RH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

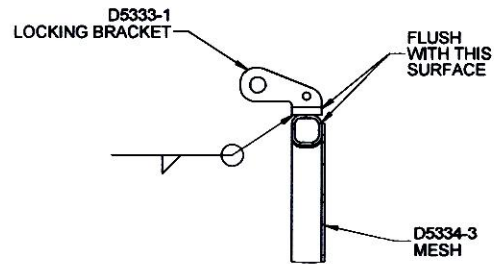
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 5.63 lbs
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

PRELIMINARY ISSUE

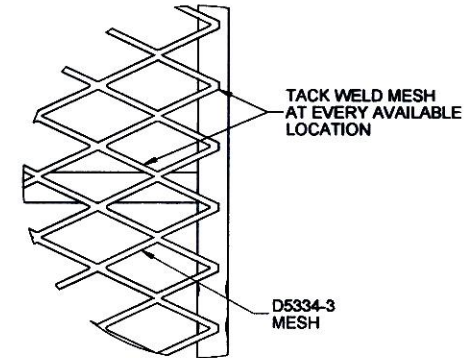
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	AK	DRAWING NO. REV. A3
MFG. APPR.	DD	D5336 SHEET 5 OF 8
APPROVED		TITLE SCALE
DE APPR.		R66/R44 BASKET LID ASSY NTS
DATE	15.08.10	COPYRIGHT © 2015 BY DART AEROSPACE LTD

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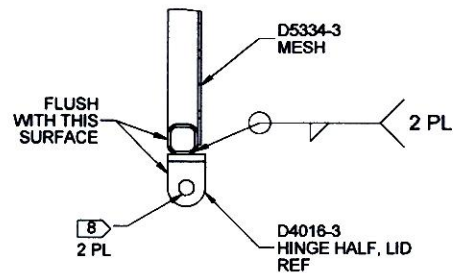
PRELIMINARY ISSUE



DETAIL G
(-043 SHOWN, -042 OPPOSITE)
C1-4
B1-5



DETAIL E
C2-4
C2-5



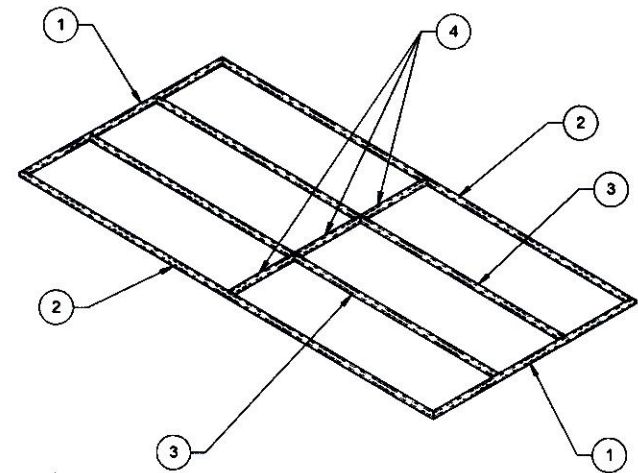
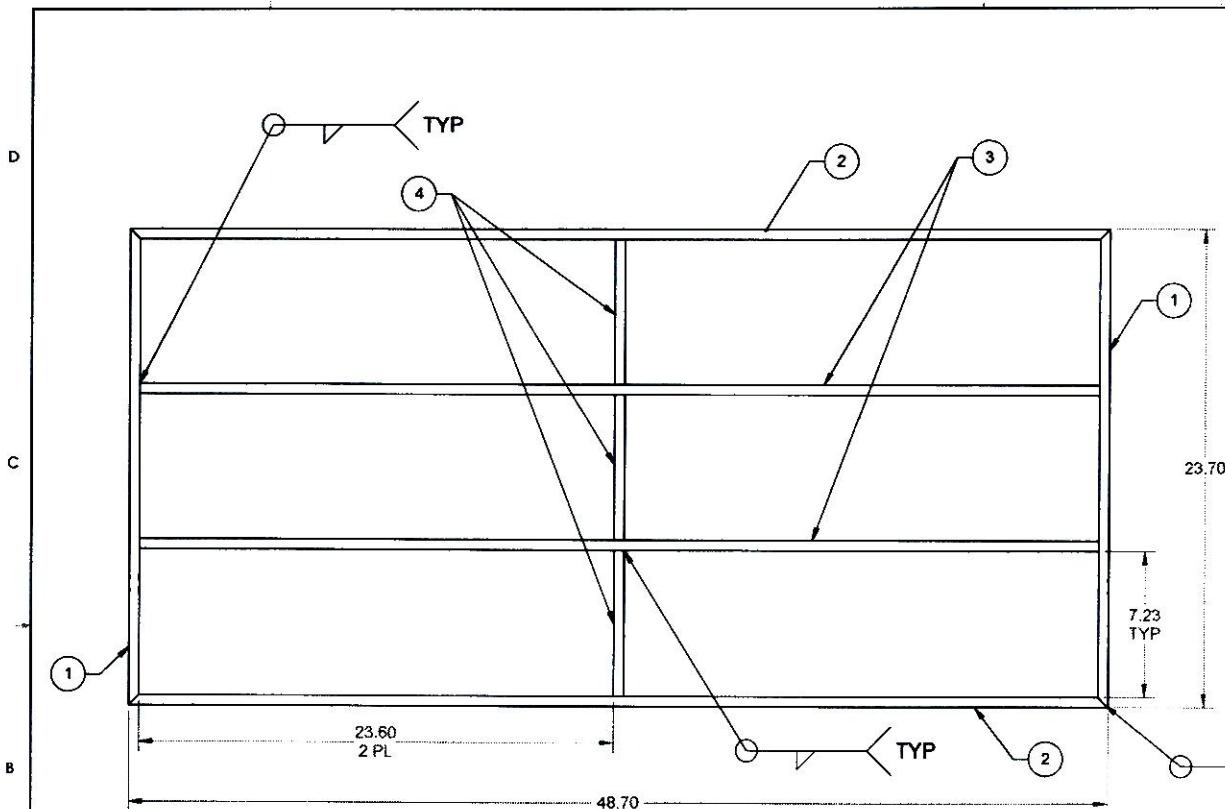
DETAIL H
(-043 SHOWN, -042 OPPOSITE)
B1-4
C1-5

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A3
MFG. APPR.	DD	D5336	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		R66/R44 BASKET LID ASSY	NTS
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PRELIMINARY ISSUE

ITEM	QTY -101	P/N	DESCRIPTION
	X	D5336-101	TUBULAR ASSEMBLY, LID
1	2	D5332-041	RIB ASSEMBLY
2	2	D5332-1	RIB
3	2	D5332-13	RIB
4	3	D5332-15	RIB



D5336-101 TUBULAR ASSEMBLY, LID

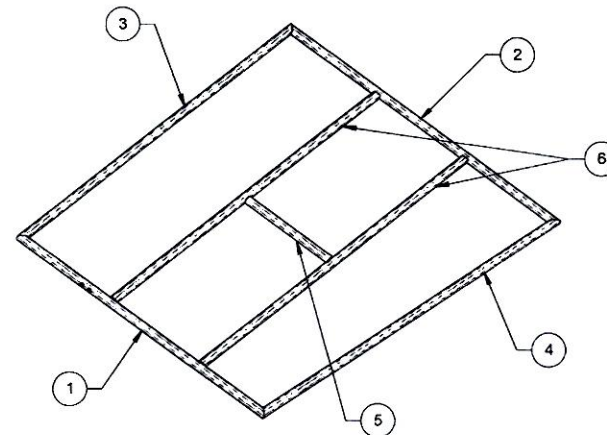
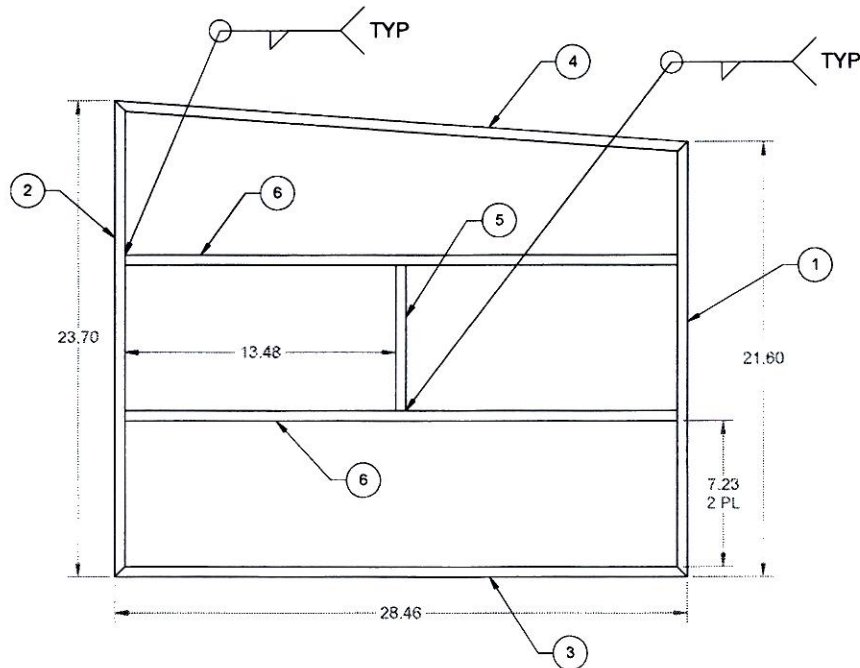
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 5.74 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D5336-101
 - 9) WELD PER DART QSI 004

PRELIMINARY ISSUE

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A3
MFG. APPR.	DD	D5336	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		R66/R44 BASKET LID ASSY	NTS
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PRELIMINARY ISSUE

ITEM	QTY -103	P/N	DESCRIPTION
	X	D5336-103	TUBULAR ASSEMBLY, LID
1	1	D5332-043	RIB ASSEMBLY
2	1	D5332-7	RIB
3	1	D5332-9	RIB
4	1	D5332-11	RIB
5	1	D5332-15	RIB
6	2	D5332-17	RIB



D5336-103 TUBULAR ASSEMBLY, LID

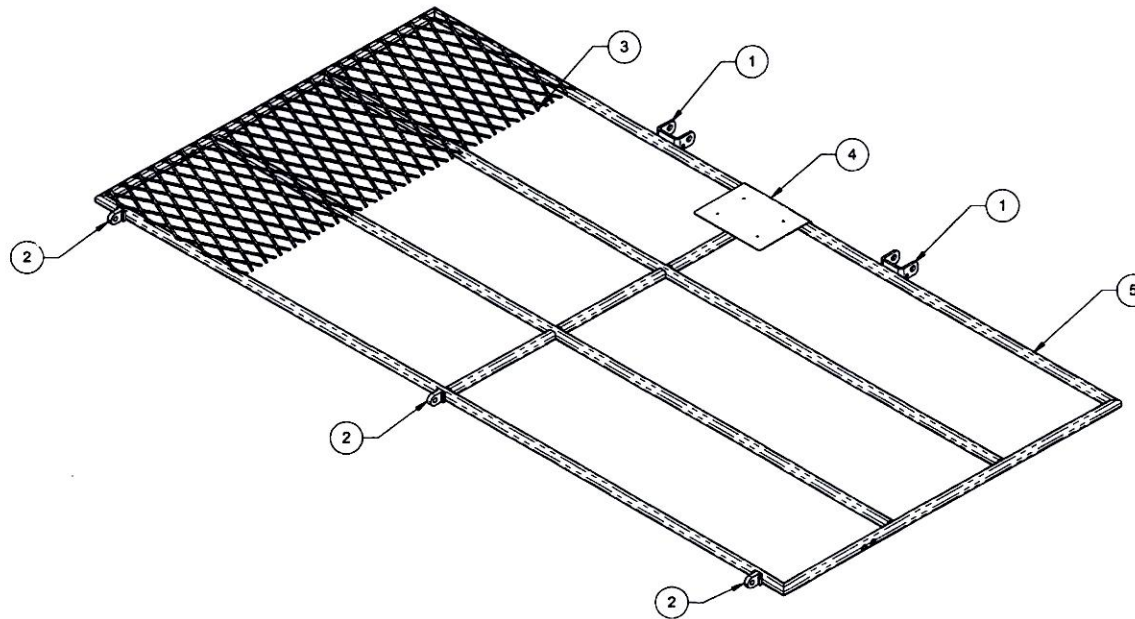
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.58 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D5336-103
- 9) WELD PER DART QSI 004

PRELIMINARY ISSUE

PRELIMINARY	DESIGN	RF	DART AEROSPACE LTD	
	DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	AK	DRAWING NO.	REV. A3
	MFG. APPR.	DD	D5336	SHEET 8 OF 8
	APPROVED		TITLE	SCALE
	DE APPR.		R66/R44 BASKET LID ASSY	NTS
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D5336-041	BASKET LID ASSY
1	2	D2581	MOUNTING BRACKET
2	3	D4016-3	HINGE HALF, LID
3	1	D5334-1	LID MESH
4	1	D5335-1	DATA PLATE
5	1	D5336-101	TUBULAR ASSEMBLY, LID



D5336-041 BASKET LID ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

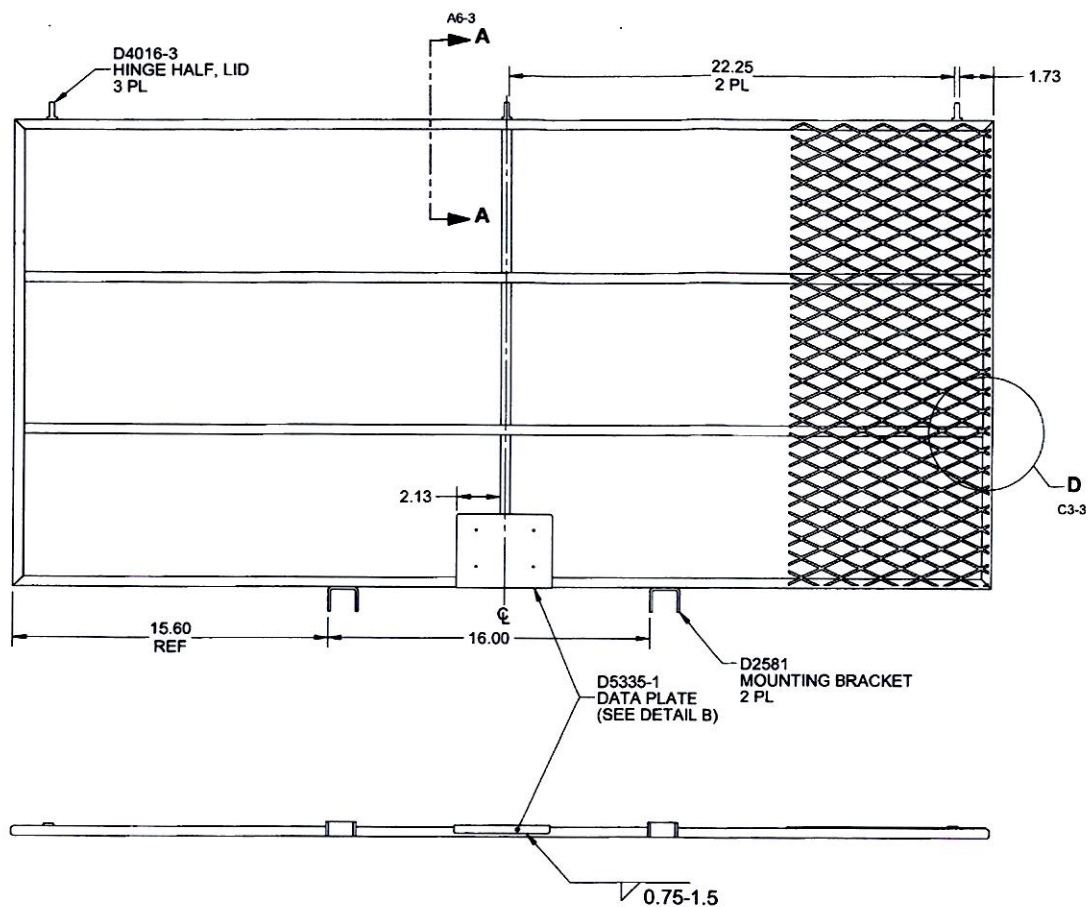
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 11.2 lbs
- 8) MASK HOLES PRIOR TO FINISHING
- 9) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.06 UNLESS OTHERWISE NOTED FOR D5336-041
- 10) WELD PER DART QSI 004

A	NEW ISSUE	RF	15.08.10
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	DD	D5336	SHEET 1 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66/R44 BASKET LID ASSY	NTS
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RELEASED
2016-01-21
EW 16-504

APPROVED



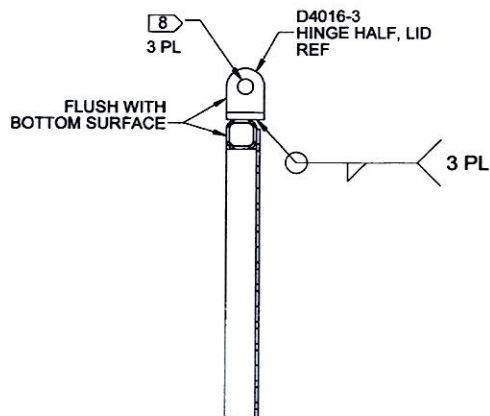
D5336-041 BASKET LID ASSY
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2016-01-21

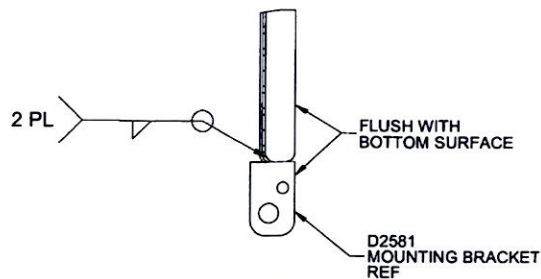
APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	DD	D5336	SHEET 2 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66/R44 BASKET LID ASSY	NTS
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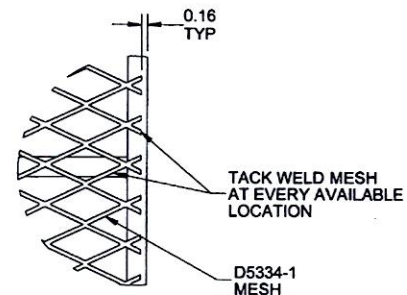
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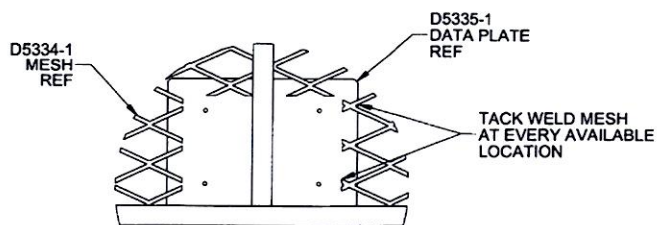
SECTION A-A
D6-2



DETAIL C
B3-2



DETAIL D
C3-2



DETAIL B
B2-2

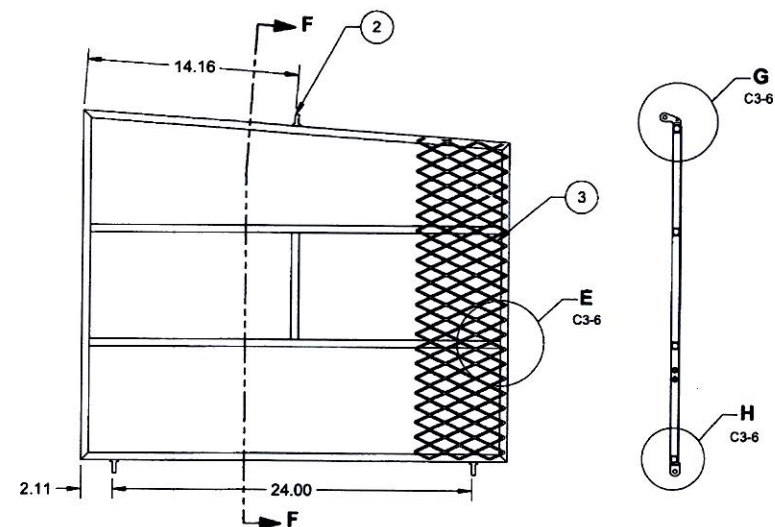
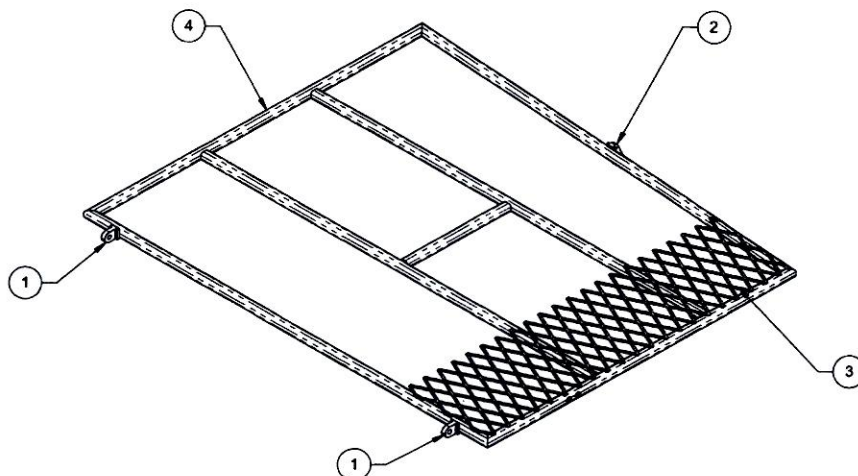
RELEASED
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	DD	D5336	SHEET 3 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66/R44 BASKET LID ASSY	NTS
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8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D5336-043	BASKET LID ASSY, LH
1	2	D4016-3	HINGE HALF, LID
2	1	D5333-1	LOCKING BRACKET
3	1	D5334-3	LID MESH
4	1	D5336-103	TUBULAR ASSEMBLY, LID



SECTION F-F

D5336-043 BASKET LID ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

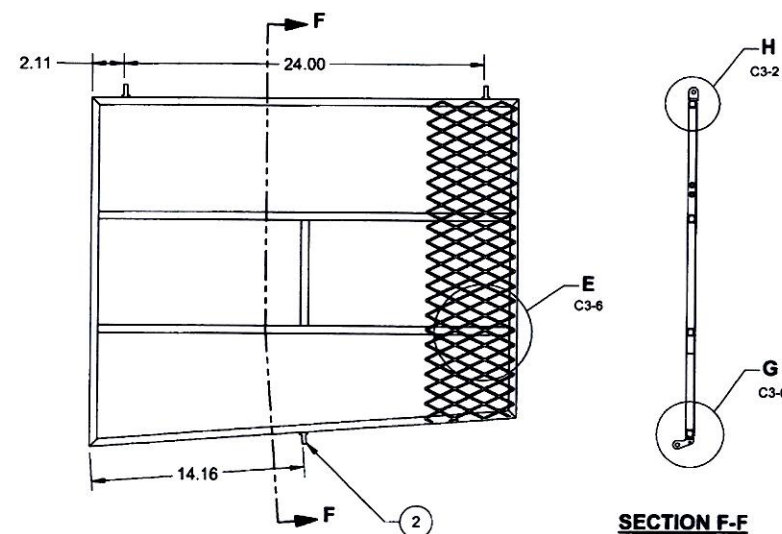
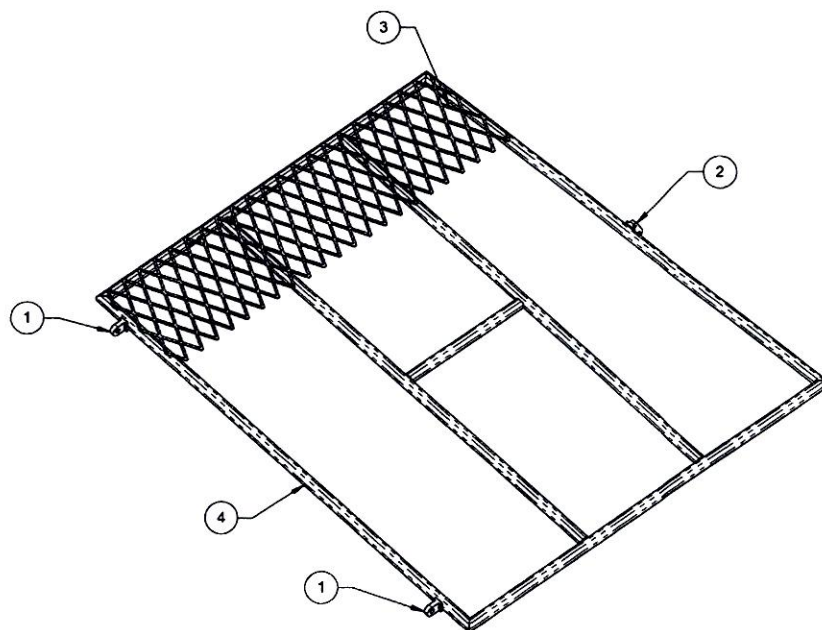
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 6.4 lbs
- 8) MASK HOLES PRIOR TO FINISHING
- 9) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.06 UNLESS OTHERWISE NOTED FOR D5336-043
- 10) WELD PER DART QSI 004

RELEASED
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO. D5336	REV. A
MFG. APPR.	DD		SHEET 4 OF 8
APPROVED	HS	TITLE R66/R44 BASKET LID ASSY	SCALE
DE APPR.	D9		NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D5336-044	BASKET LID ASSY, RH
1	2	D4016-3	HINGE HALF, LID
2	1	D5333-1	LOCKING BRACKET
3	1	D5334-3	LID MESH
4	1	D5336-103	TUBULAR ASSEMBLY, LID



D5336-044 BASKET LID ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

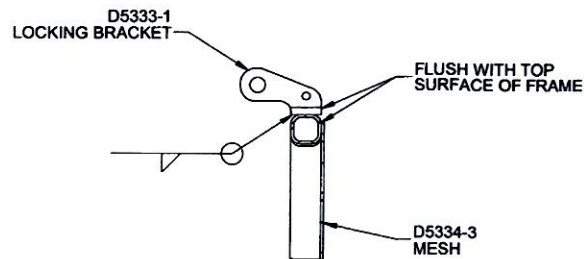
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 6.4 lbs
- 8) MASK HOLES PRIOR TO FINISHING
- 9) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.06 UNLESS OTHERWISE NOTED FOR D5336-044
- 10) WELD PER DART QSI 004

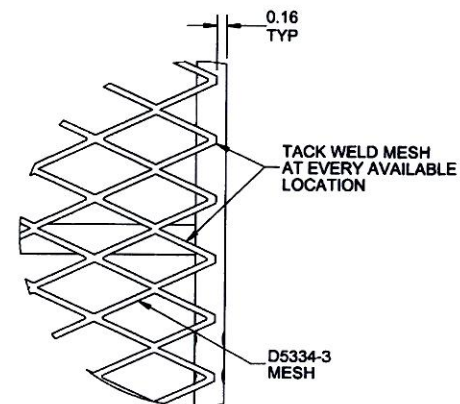
RELEASED
2016-01-21

APPROVED

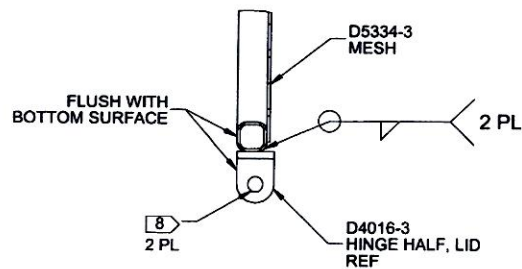
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	DD	D5336	SHEET 5 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66/R44 BASKET LID ASSY	NTS
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DETAIL G
(-043 SHOWN, -044 OPPOSITE)
C1-4
B1-5



DETAIL E
C2-4
C2-5



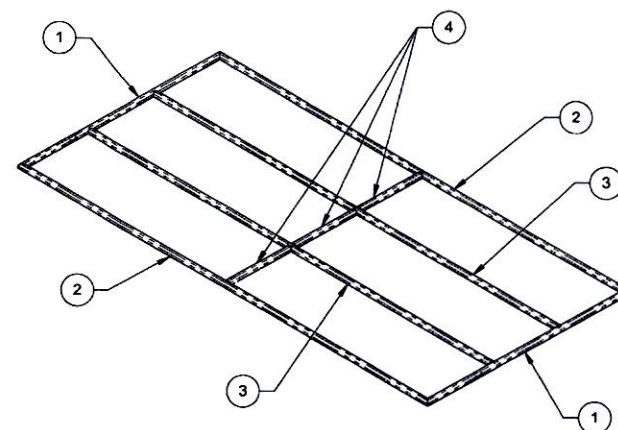
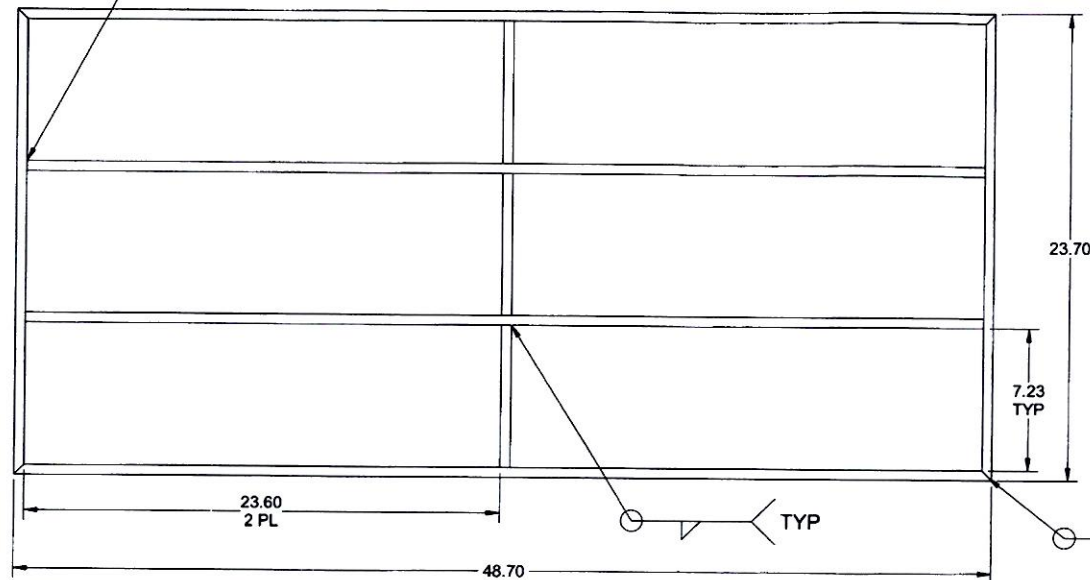
DETAIL H
(-043 SHOWN, -044 OPPOSITE)
B1-4
C1-5

RELEASED
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	DD	D5336	SHEET 6 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66/R44 BASKET LID ASSY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D5336-101	TUBULAR ASSEMBLY, LID
1	2	D5332-041	RIB ASSEMBLY
2	2	D5332-1	RIB
3	2	D5332-13	RIB
4	3	D5332-15	RIB



D5336-101 TUBULAR ASSEMBLY, LID

NOTES:

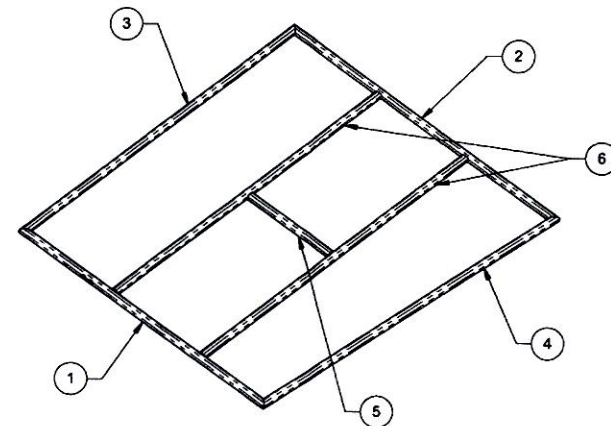
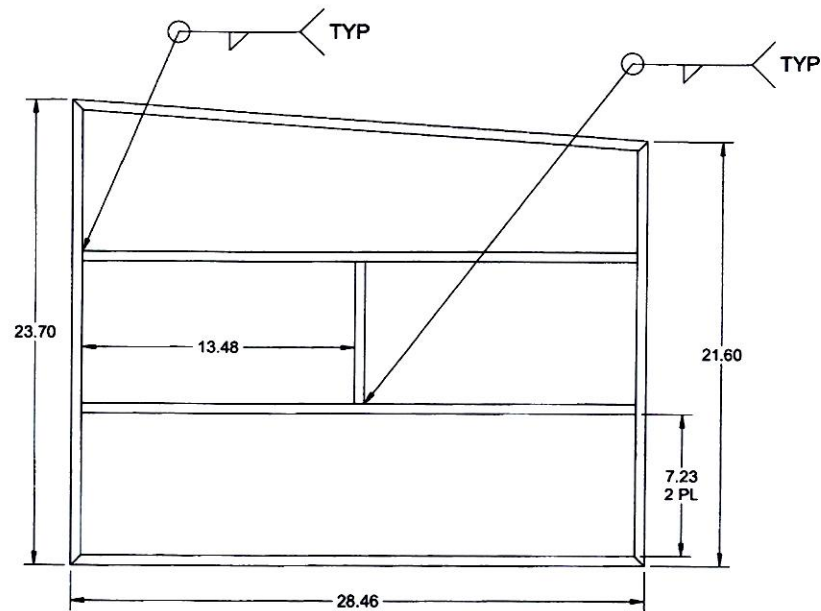
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 5.74 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.100 UNLESS OTHERWISE NOTED FOR D5336-101
- 9) WELD PER DART QSI 004

RELEASED
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. A
MFG. APPR.	DD	D5336	SHEET 7 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66/R44 BASKET LID ASSY	NTS
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ITEM	QTY -103	P/N	DESCRIPTION
	X	D5336-103	TUBULAR ASSEMBLY, LID
1	1	D5332-043	RIB ASSEMBLY
2	1	D5332-7	RIB
3	1	D5332-9	RIB
4	1	D5332-11	RIB
5	1	D5332-15	RIB
6	2	D5332-17	RIB



D5336-103 TUBULAR ASSEMBLY, LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.58 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.100 UNLESS OTHERWISE NOTED FOR D5336-103
- 9) WELD PER DART QSI 004

RELEASE
2016-01-21

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO. D5336	REV. A
MFG. APPR.	DD		SHEET 8 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66/R44 BASKET LID ASSY	NTS
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